DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 1.28

WELDING INSPECTION REPORT

Resident Engineer: Casey, William
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-026881
Date Inspected: 13-Dec-2011

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: American Bridge/Fluor Enterprises, a JV

OSM Arrival Time: 700
OSM Departure Time: 1730
Location: Job Site

CWI Name:	See Below			**CWI Present:**	☑ Yes	☐ No	
Inspected CWI report:	☐ Yes	☑ No	☐ N/A	**Rod Oven in Use:**	☑ Yes	☐ No	☐ N/A
Electrode to specification:	☑ Yes	☐ No	☐ N/A	**Weld Procedures Followed:**	☑ Yes	☐ No	☐ N/A
Qualified Welders:	☑ Yes	☐ No	☐ N/A	**Verified Joint Fit-up:**	☑ Yes	☐ No	☐ N/A
Approved Drawings:	☑ Yes	☐ No	☐ N/A	**Approved WPS:**	☑ Yes	☐ No	☐ N/A
				Delayed / Cancelled:	☐ Yes	☑ No	☐ N/A

Bridge No: 34-0006
Component: OBG

Summary of Items Observed:

At the start of the shift this Quality Assurance Lead Inspector (QAI) traveled to the SAS project site and observed the work and the inspection performed by American Bridge/Fluor Enterprises (AB/F) Quality Control (QC) personnel. The observations and inspections were performed as noted below:

A). This Quality Assurance Lead Inspector (QALI) assigned the QA Inspectors to the following, but not limited to the work station(s) listed , to observe the welding and the QC inspection of the following:

Douglas Frey-OBG W11(Observation of the welding and QC inspection on the Lifting Lug Holes), OBG Field Splice W13/W14 (Observation of the welding and QC inspection of "D2" Plate) and OBG Field Splice W13/W14 (Observation of Repair Welding and QC Inspection of Plates "D1").

Joselito Lizardo-OBG E14 (Observed the Repair Welding and Inspection of the Ventilation Holes), OBG E11 (Observation of the welding on the Lifting Lug Holes) OBG E13/E14 Field Splice (Observation of Welding and QC inspection on "E2" Side Plate), FW Spencer, South Tower Shaft (Observation of the utility pipe welding) and MPT of Weld Repair on Jacking Saddle Frame.

Art Peterson-CCO: 179 Item 2-Continued observation of the welding and QC Inspection of the pipe sleeve at the bike path divider panels and installation of the pipe sleeve at the South Rail Divider.

William Clifford-OBG E14 (QA/UT, information only, of Ventilation Holes with QA UT Level III, Robert Mertz) and observed QC/UT at OBG Field Splices W12/W13, W13/W14 and E13/E14.

Quality Assurance Lead Inspector (QALI) Summary

This QA Lead Inspector (QALI) observed the QA Inspector's Douglas Frey, Art Peterson, Joselito Lizardo and William Clifford and Joselito Lizardo monitor the work performed by the QC inspectors at random intervals and also observed the QA Inspectors verify the welding parameters, the minimum preheat and the maximum interpass temperatures for compliance with the contract specifications. The QAI's utilized a Fluke 337 clamp meter to measure the electrical welding parameters, Tempil Heat Indicators and/or a Fluke 63 IR Thermometer for verifying the preheat and interpass temperatures. At the conclusion of the shift, this QA Lead Inspector discussed and reviewed the work performed by the QAI's in regards to the various observations and the verifications of the WPS's, consumables, welding parameters, preheat and interpass temperatures. The QAI observations of the QC inspection and verification of the welding parameters performed on this date appeared to comply with the contract specifications and no issues were noted on this date.

For additional information see Summary of Conversation.

See QA daily Weld Inspection Reports (WIR) for additional information and details.

This QA Inspector continued the daily review of field inspection reports and update of the field document control tracking records regarding the Orthotropic Box Girders (OBG, Longitudinal and Transverse "A" Deck Stiffeners, Deck Access Holes and the Tower Shear plates).

Summary of Conversations:

There were general conversations with Quality Control Lead Inspector, Bonifacio Daquinag, Jr., at the start of the shift regarding the location of welding, inspection personnel scheduled for this shift.

The QA inspector, William Clifford, indicated in conclusion of the investigative Ultrasonic Testing performed on the ventilation holes regarding the indications located in the vacinity of the closed rib, it appeared to be caused by mode conversion due to the joint geometry because the indications could not be confirmed and no repeatable signal could not be detected.

In regards to CCO: # 182, this QALI was informed by QC Lead Inspector, Bonifacio Daquinag, that the QC department would be performing the MT at the areas where the temporary attachments have been removed and ground flush from the top and side face of the counterweights located along the north side of the west bound box girders. He also indicated that this would happen at a later date. This was also confirmed by ABF Field Supervisor, Scott Smith. Mr. Smith also indicated that the removal of the paint would be performed when ABF personnel would start the welding on the cover plates of the counterweights.

In regards to the few that have been ground flush and not painted, the testing cannot be performed due to the absence of a safety line.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or

remedial efforts please contact Nina Choy 510-385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Reyes,Danny	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer